

Date: Tuesday, 12/18/2007 10:45:51 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPRING  
 Job Number : 36397  
 Estimate Number : 10497  
 P.O. Number : *NIA*  
 This Issue : 12/18/2007 S.O. No. : *NIA*  
 Prsht Rev. : NC  
 First Issue : *NIA* Type : PURCHASED PARTS  
 Previous Run : 34590  
 Part Number : D2535  
 Drawing Number : D2535 REV. A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : *NIA*  
 Due Date : 12/31/2007 Qty: 50 Um: Each  
 Written By : *JA*  
 Checked & Approved By : *JA 07.12.18*  
 Comment : Est. A 99.04.19 New Issue (From hand written IPP) DM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *5017**0207112119**(50)*

Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring

2.0 D2535P Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)  
 SPRING

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

*CU 7/12/21 50*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK  
 Check dims to dwg

*AS 07/12/04 (50)*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SI 36**AS 07/12/27 (50)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: AD Date: 08/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:45:51 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 36397

Part Number: D2535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



58

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/03

Job Completion



mi 2008/1/2

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

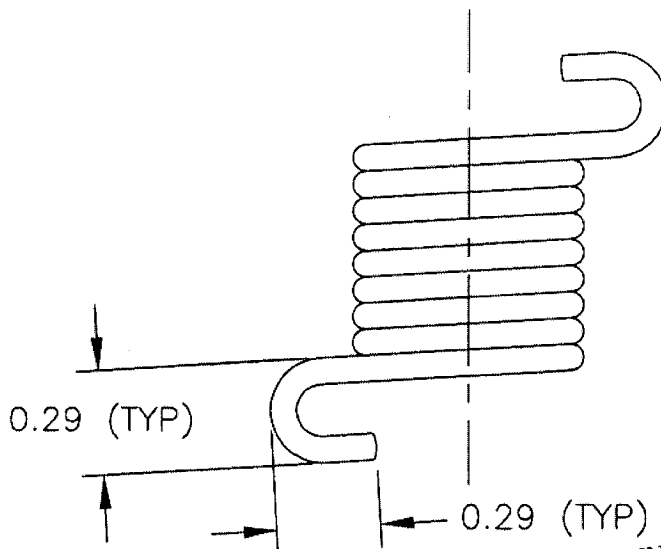
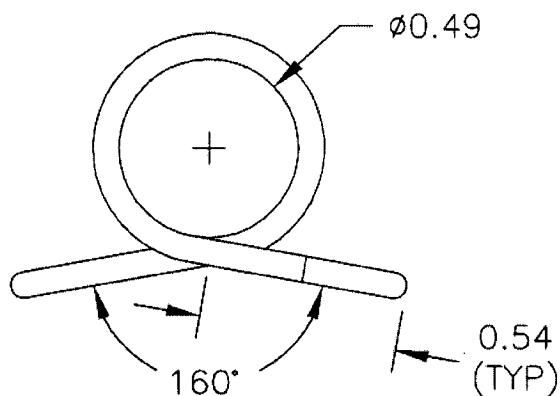
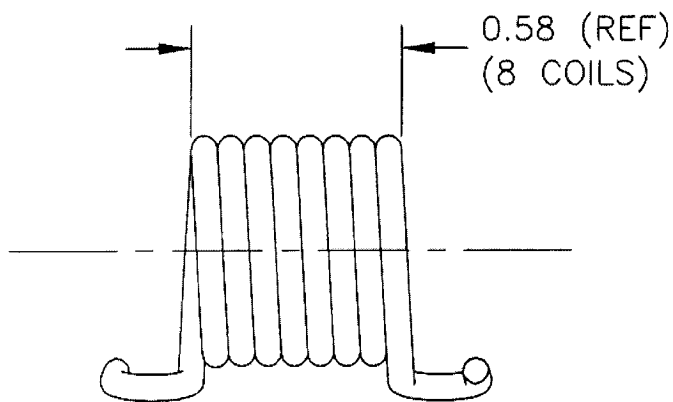
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08	TITLE SPRING SPEC CONTROL		SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED  
99.05.11 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36397

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL  $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#2 6104 - 82 Ave, Edmonton AB T6B 0E7  
Tel: (780) 442-4020 • Fax: (780) 468-1946

INVOICE 17764

PRECISION COIL SPRINGS AND WIRE FORMS

BILL TO: Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawkesbury ON K1A 1K7

SHIP TO:

DATE		ORDER No.	SHIP VIA	
20-Dec-07		5317	Fed Ex 151793240	
QUANTITY	DESCRIPTION		UNIT	AMOUNT
50	D2535F Torsion Spring		4.56	228.00
<div>Thank you!</div> <div>WE APPRECIATE YOUR BUSINESS</div>				
GST #	TERMS	SUBTOTAL	FREIGHT	TOTAL
854454527	NET 30 DAYS	228.00		241.68

REPORT FOR: Dart Aerospace Ltd.		DATE: 12/20/2007
PO # 5317 5017	PART/DRAWING #: D2535P	
SPRING DESCRIPTION: Torsion Spring		QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	0.070"	Yes	
I.D.	.490"	0.495	
O.D.			
Number of Coils	8 Ref.	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per dwg.		
Rate (lb/in)			
Finish			

### COMMENTS

Mill Certificate attached: N  
Material Heat Number: NA

Certified by: Jeremy Burrows